

Amendments to the Claims

1. (Currently Amended) A continuous method of cutting a plurality of moist substrates comprising:

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- a) placing a wound log of moist substrate on a conveyor, the log having a length, a width and a moisture content of at least about 50%;
 - b) advancing the conveyor;
 - c) discharging the log from the conveyor onto a transfer plate;
 - d) placing the log into a pocket on a cutting support;
 - e) advancing the pocket containing the log toward a plurality of cutting blades;
 - f) advancing the pocket containing the log through the cutting blades, whereby the log is cut into a number of shorter rolls;
 - g) advancing the pocket containing the rolls away from the cutting blades;
 - h) discharging the rolls from the pocket; and,
- repeating steps a) through h) in a continuous manner.

2. (Original) The method of claim 1, wherein the log is at least 2540 mm long.

3. (Original) The method of claim 1, wherein the log has a diameter of from about 50 mm to about 140 mm.

4. (Original) The method of claim 1, wherein at least 95% of the log is cut into useable rolls.

5. (Original) A method of cutting a coreless wet wipes log comprising:

- a) placing a coreless wet wipes log in a pocket, the log having a length of at least 2540 mm, a diameter of from about 50 mm to about 140 mm and a moisture content of at least 50%;
- b) advancing the pocket containing the log toward a cutting position;
- c) cutting the log into a plurality of rolls in the cutting position;

d) the pocket maintaining the shape, integrity and position of the log as it is cut into rolls without the need for clamps and without the need for a mandrel; and,
e) discharging the rolls from the pocket.

6. (Original) The method of claim 5, wherein steps a) through e) are repeated in a continuous process resulting in the production of at least 300 rolls per minute.

7. (Original) The method of claim 5, wherein a conveyor is used to place the logs in the pockets.

8. (Original) The method of claim 5, wherein the rolls are discharged into a diverter.

9. (Original) The method of claim 5, wherein at least 95% of the log is cut into useable rolls.

10. (Original) A method of making a plurality of wet wipes rolls comprising:
a) placing a wet wipes log on a conveyor, the log having a length, a width and a moisture content of at least about 65%;
b) advancing the conveyor;
c) discharging the log from the conveyor into a holding support;
d) advancing the support containing the log toward a plurality of cutting blades;
e) engaging the log and the cutting blades, whereby the log is sectioned into a plurality of rolls; and,
repeating steps a) through e) so that at least 300 rolls are produced per minute.

11. (Original) The method of claim 10, wherein the log is at least 2540 mm long.

12. (Original) The method of claim 10, wherein the log has a diameter of from about 50 mm to about 250 mm.

13. (Original) The method of claim 10, wherein at least 95% of the log is cut into useable rolls.

14. (Original) A continuous method of cutting a plurality of wet wipes logs comprising:

- a) placing a coreless wet wipes log on a conveyor, the log having a length, a width and a moisture content of at least about 50%;
- b) advancing the conveyor;
- c) discharging the log from the conveyor onto a transfer plate;
- d) metering the rate at which the log is discharged from the transfer plate to a pocket;
- e) advancing the pocket containing the log toward a plurality of cutting blades;
- f) engaging the log in the pocket with the cutting blades, whereby the log is cut into a number of shorter rolls;
- g) discharging the rolls from the pocket;
- h) repeating steps a) through g) in a continuous manner; and, periodically interrupting the repetition of steps a) through g) to move the cutting blades to a position away from pocket; and, honing the cutting blades while in the away position, whereby material from the honing does not contaminate the pocket, the log, or the rolls.

15. (Original) The method of claim 14, wherein the log is at least 2540 mm long.

16. (Original) The method of claim 14, wherein the log has a diameter of from about 50 mm to about 140 mm.

17. (Original) The method of claim 14, wherein at least 95% of the log is cut into useable rolls.

31. (Original) A method of cutting a plurality of flexible substrates comprising:

- a) placing a flexible log on a conveyor, the log having a length and a width;
- b) advancing the conveyor;
- c) discharging the log from the conveyor into a holding support;

d) advancing the support containing the log toward a plurality of cutting blades;

e) engaging the log and the cutting blades, whereby the log is sectioned into a plurality of rolls; and,

repeating steps a) through e) so that at least 300 rolls are produced per minute.

32. (Original) The method of claim 31, wherein the log is at least 2540 mm long.

33. (Original) The method of claim 31, wherein the log has a diameter of from about 50 mm to about 250 mm.

34. (Original) The method of claim 31, wherein at least 95% of the log is cut into useable rolls.

35. (Original) A continuous method of cutting a plurality of flexible logs comprising:

a) placing a flexible log on a conveyor, the log having a length and a width;

b) advancing the conveyor;

c) discharging the log from the conveyor onto a transfer plate;

d) metering the rate at which the log is discharged from the transfer plate to a pocket;

e) advancing the pocket containing the log toward a plurality of cutting blades;

f) engaging the log in the pocket with the cutting blades, whereby the log is cut into a number of shorter rolls;

g) discharging the rolls from the pocket;

h) repeating steps a) through g) in a continuous manner; and, periodically interrupting the repetition of steps a) through g) to move the cutting blades to a position away from pocket; and,

honing the cutting blades while in the away position, whereby material from the honing does not contaminate the pocket, the log, or the rolls.

36. (Original) The method of claim 35, wherein the log is at least 2540 mm long.

37. (Original) The method of claim 35, wherein the log has a diameter of from about 50 mm to about 140 mm.

38. (Original) The method of claim 35, wherein at least 95% of the log is cut into useable rolls.

39. (Original) A continuous method of cutting a plurality of substrates comprising:

a) placing a log of substrate on a conveyor, the log having a length and a width;

b) advancing the conveyor;

c) discharging the log from the conveyor onto a transfer plate;

d) placing the log into a pocket on a cutting support;

e) rotating the pocket containing the log toward a plurality of circular cutting blades;

f) rotating the pocket containing the log through the circular cutting blades, whereby the log is cut into a number of shorter rolls;

g) rotating the pocket containing the rolls away from the cutting blades;

h) discharging the rolls from the pocket; and,

repeating steps a) through h) in a continuous manner.